

Date: Tuesday, 4/17/2007 3:57:07 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 31937		
Estimate Number	: 12712		
P.O. Number	: <i>N/A</i>	Part Number	: D35371
This Issue	: 4/17/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3537 UNDER REVIEW <i>PH</i>
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 31725	Drawing Revision	: <i>AB</i>
	Type : SMALL /MED FAB	Material	: <i>N/A</i>
Written By	:	Due Date	: 5/20/2007
Checked & Approved By	:	Qty:	40 Um: Each
Comment	: Est Rev:A New Issue 07-02-14 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0788 sf(s)/Unit Total : 3.1500 sf(s)  
 M304S16GA .063" 304 SS SHEET  
 Batch: *M103961*

*SAP 07/05/13*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3537  
 Dwg Rev: *B*  
 Prog Rev: *B*

*SAP 07/05/13*

2-Deburr if necessary

*MF 07-05-17*

*(40)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAP 07/05/13*

*(40)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*BF 07-05-14*

*40*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.  
 2-Identify as D3537-1

*MF 07-05-17 (40)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/14

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:57:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31937

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty

Description

Batch

A/R

2059B Hardcoat

M102956

FC 07/06/13 40

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/12 40

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/12 40

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101001

BR

07-06-13 40

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/06/13 40X

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FLP 18

M-L

07/06/13 40X

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/14 40

Job Completion



U 07/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

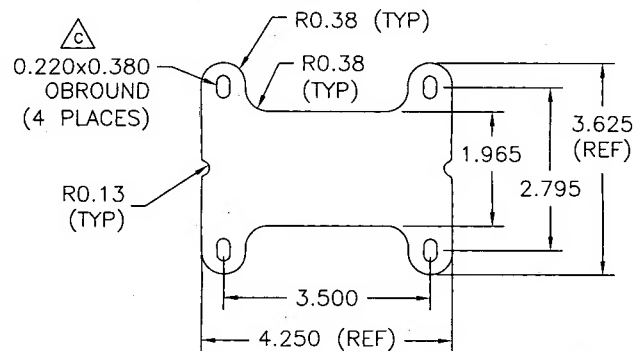
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

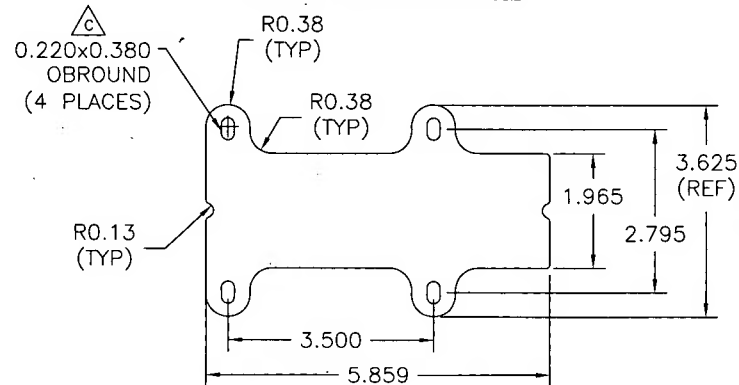
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

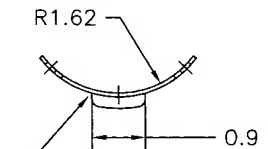
### D3537-1F FLAT PATTERN



### D3537-3F FLAT PATTERN

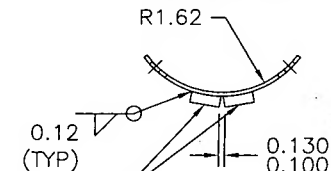


### SECTION A-A



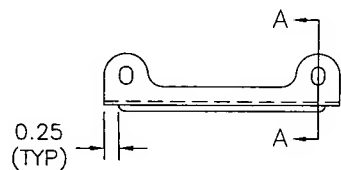
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

### SECTION B-B

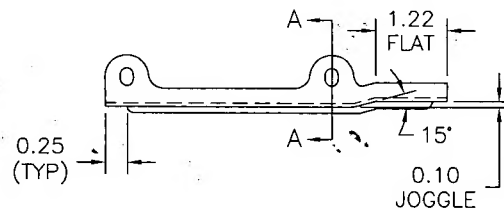


D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

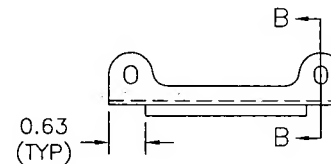
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



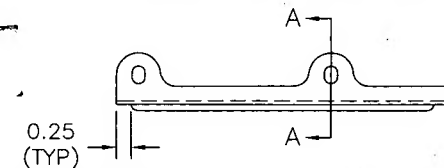
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	#	APPROVED #
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C SHEET 1 OF 1 SCALE 1:2

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

~~31725~~

DART AEROSPACE LTD		Work Order:	31725
Description: Wearpad		Part Number:	D3537-1
Inspection Dwg: D3537 Rev: A B		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

**X**

## First Article

1

## Prototype

[illegible]

Measured by:	SAD	Audited by:	SG	Prototype Approval:	N/A
Date:	03/05/13	Date:	07.05.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	